

Work Order ID: 61361

Thursday, August 19, 2010 1:38:15 PM



Page 1

Item ID: D2274

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 8/20/2010 Start Qty: 160.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 160.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-8-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								
100	SHEAR	0.00							
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 9 pieces								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2274								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

LF 10/09/04

162

LF 10/09/04

162

LF 10/09/04

162

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

JP 10/09/05

0.00

162

/

Memo

140



Small Fab

Small Fab

Small Fab

0.00

0.00

Memo

Tumble ☐ Deburr any rough edges after tumbling

B16-9-8

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

B10-9-9

0.00

Memo

162

W/O:		WORK ORDER CHANGES					
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Start Date: 8/20/2010 Start Qty: 160.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 160.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

10/09/08

162

Ø

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: ST/0

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 61361



Parent Item: D2274



Parent Item Name: Radius Block

Start Date: 8/20/2010

Required Date: 8/26/2010

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP H 00.05.18 Added inspection level 8 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	99.3017	0.0916	15.42737			



6061-T6 Bar .750 x .125

Location

Loc Qty

Loc Code

MAT01

99.3017

113608

79.6

113680

1.4947

113719

18.207

15.4274 8/19/09/04

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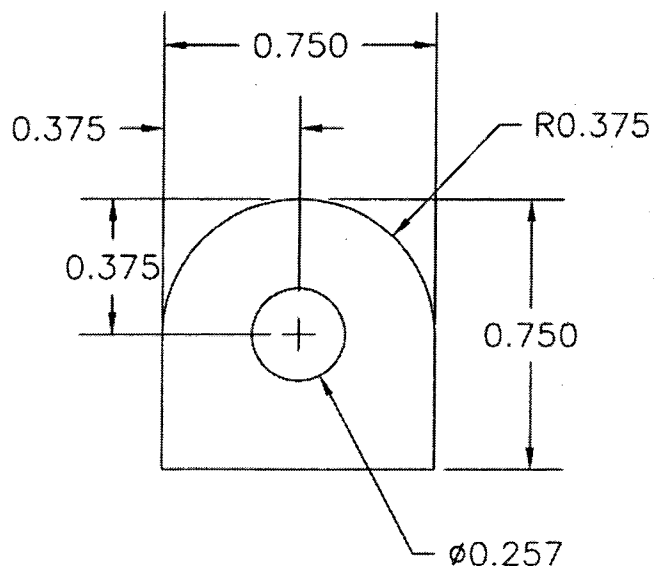
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE



#61361

#00.05.16
#00.05.16

0.063 x 45° CHAMFER
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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